

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 151896

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151896

Page 2

Item ID: 646.9603

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Cutter Assy Low

Start Date: 11/18/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/23/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location <u>CK 030</u>	0.00							
140									
Packaging	Memo	0.00				<u>2</u>	DAS 6 9-89		NOV 2 1 2016
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.03							16/11/21 <u>JD</u>
Quality Control									

DAS
21
9-89

NOV 2 1 2016

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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 151896

151896

Parent Item: 646.9603

646.9603

Parent Item Name: Lower Cutter Assy Low

Start Date: 11/18/2016

Required Date: 11/23/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No			110	Each	6.0000	1	2			

646.9701

Cutter Sub Assembly

**

NOV 16 2016

68-6
9
DAS

Location

Loc Qty

Loc Code

CCK007

6

149605

6

646.9813

Manufactured

No

110

Each

8.0000

1

2

**

NOV 16 2016

68-6
9
DAS

Location

Loc Qty

Loc Code

CCK015

8

142493

8

MS21042L08

Purchased

No

110

Each

686.0000

3

6

**

NOV 16 2016

68-6
9
DAS

Location

Loc Qty

Loc Code

GA

100

m135274

100

ST303

586

m134063

2

m135566

184

m135672

200

m135766

200

MS21042L08

Nut

Picklist Print

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Page 2

Work Order ID: 151896

151896

Parent Item: 646.9603

646 9603

Parent Item Name: Lower Cutter Assy Low

Start Date: 11/18/2016

Required Date: 11/23/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

376.0000

3

6

MS27039-08-19

Screw

**

136042X1

DAS
6
9-89

NOV 16 2016

Location

Loc Qty

Loc Code

ST277

376

m135536

9

m135566

267

m135865

100

NAS1149FN832P

Purchased

No

110

Each

2,265.000

6

12

NAS1149FN832P

Washer

**

DAS
6
9-89

NOV 16 2016

Location

Loc Qty

Loc Code

GA

1537

M133769

89

M135058

1448

ST263

728

M135603

728

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OTHER : _____					

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600		REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: CUTTER ASSY					
	APPROVED BY:	ENGR. <i>H. Brans</i>	MFG. <i>Armit Jones</i>	QC <i>Walter Lopez</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED SCREW LENGTH.				

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151896 MLJ
161017

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☐ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVES
	LAST PROTOTYPE VERSION #81		HUC
HUC	VIRAL RELEASE	04/30/09	P. BOPAYO



1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

1			8	646.9813	LOWER DEFLECTOR LOW	
	1		7	646.9812	LOWER DEFLECTOR HIGH	
		1	5	646.9811	UPPER CUTTER DEFLECTOR	
A/R	A/R	A/R	5	601.2045	RTV, LOCITE 598	
3	3	3	4	601.1541	LOCKNUT	M321042L08
3	3	3	3	601.2765	SCREW	M327039-081P
5	6	6	2	601.2764	WASHER	M4112449F082P
1	1	1	1	646.9701	CUTTER SUB ASSY	
				646.9603	LOWER CUTTER ASSY LOW	
				646.9602	LOWER CUTTER ASSY HIGH	
				646.9601	UPPER CUTTER ASSY	
.9603	.9602	.9601	FIND #	PART #	DESCRIPTION	MATL SPEC
QTY			PARTS LIST			
NEXT ASSY (5)			ORIGINAL DATE MO/DO/YR 1/24/2018 DRAWN BY J. DRAHMER CHECKED BY J. BRAYD APPROVAL [Signature] DATE 1/24/2018 SUBMIT CORRECTION NO. UNITS OTHERWISE SPECIFIED DIMENSIONS = IN. & FRACTIONS TOLERANCES ARE: FRACTIONS DECIMALS ANGLES .0005 .001 .005 .001 .001 .001			
646.9500						
			APICAL INDUSTRIES 2808 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300 CUTTER ASSY SIZE CASE CODE DWD HDS B 07M26 646.9600 SCALE NONE			
			1 SHEET 1 OF 1			